

NCR-19-7667



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4151-7

Job Sheet 197437



Part No: D4151-7

Job Qty: 20 pcs

Part Name: Fwd Eyebolt Receiver (Upper)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/8/19

Job Tracking No:

Due Date: 7/15/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV C SHEET 3 IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD IPP Rev:B 11.01.21 as per
dwg revC DD verf:JLM IPP Rev:C Change mat'l size JFS 17.01/25 Verified by: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs	7/15/19	7/15/19	0.00	0.77	Bandsaw - 1		DJP 19-07-13
110	HAAS 5 Axis - B4B	20 pcs	7/15/19	7/15/19	0.75	22.47	HAAS - 5 - B4B		DJP 19-07-13
120	QC 2	20 pcs	7/15/19	7/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		
							QC 2 - 5		
							QC 2 - 71		
							QC 2 - 73		
							QC 2 - 69		
130	QC 8	20 pcs	7/15/19	7/15/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		



Container No: S197685



Part: D4151-7

Job No: 197437

Serial No/Batch: S197685

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/13/19

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 7/8/19 1:10 PM Dart.Renwick.Jennifer

7/8/2019

[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	Dr 19-07-19
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
140 Packaging 3-1 - Stock - B4B 20 pcs	7/15/19	0.00	0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC 57082
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	20 pcs	7/15/19	0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - (Bandsaw) Cut blank to 2.960" long Descriptions: 110 - (HAAS CNC vertical machine #5) 1-MILL as per folio FA952 & dwg , 120 - (QC2- Inspect parts off machine FA/FAIB) 130 - (QC8- Inspect parts - second check) 140 - Identify as per dwg & Stock Location: _____ 150 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M304B1.500X1.500	M304 Bar 1.500 x 1.500	5 ft (.25 ea)	100-Bandsaw - 1	5092574	
M303BAR 2.00X1.750					

$$\begin{array}{r}
2.960 + .050 \\
\hline
3.01 \times 21 \\
\hline
63.21'' \div 12 \\
\hline
5.2675' \\
\hline
5.250 \\
\hline
0.0175 \text{ Scrap}
\end{array}$$

MAT
w/ep
4.630'
(4.8615)

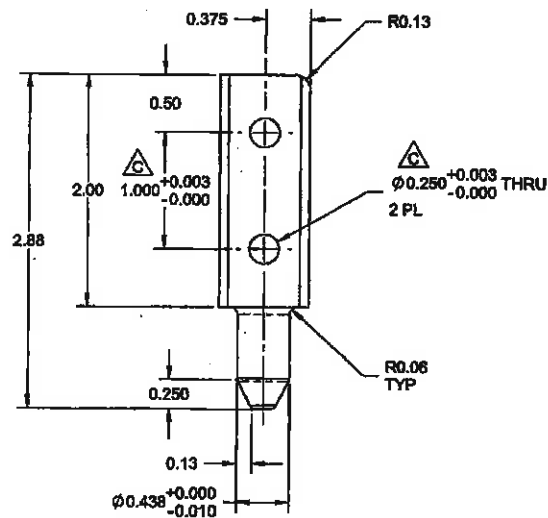
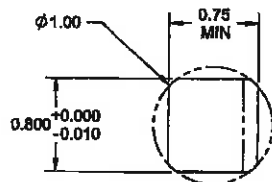
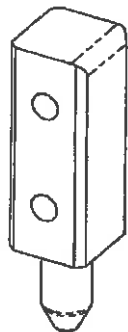
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7/8/2019

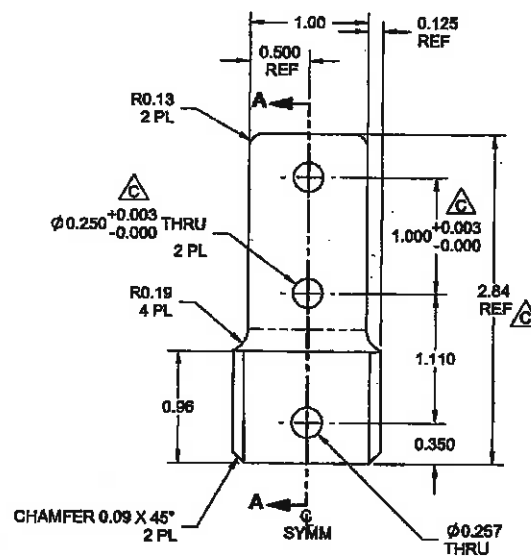
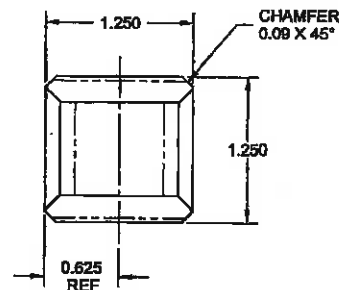
[Dart Hawkesbury] Job Sheet - Renwick, Jennifer

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M304B1.500X1.500 M303B2.00X1.750	5	20	0
Part Specifications				
Specifications could not be found.				

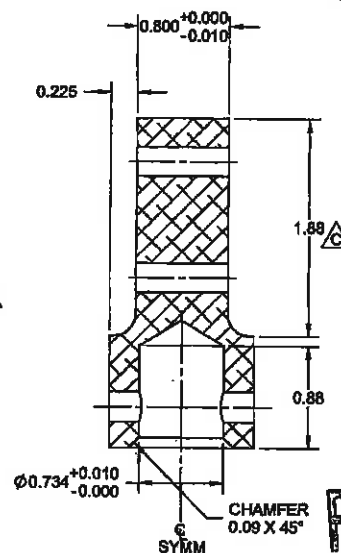
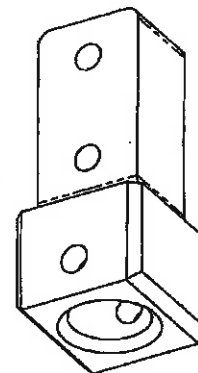
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D4151-5 FWD BASKET INSTL STUD (LOWER)



D4151-7 FWD EYEBOLT RECEIVER (UPPER)



SECTION A-A

NOTES:

- 1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
-7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.38 lbs
-7: 0.70 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4151	REV. C
MFG. APPR.		TITLE BASKET FWD HARDPOINT	SHEET 3 OF 3
APPROVED		DATE 10.12.14	SCALE NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
		THIS DOCUMENT IS UNCLASSIFIED AND CONTAINS NO INFORMATION THAT IS UNCLASSIFIED OR CONTROLLED UNDER THE ACCESS TO INFORMATION ACT	
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RELEASED
2011-11-12
RELEASED

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 76 Date: Oct 31/19Work Order update only ☐

Work Order: <u>197437</u> Part No. <u>D4151-7</u> NCR No. <u>19-7667</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Date: <u>19-07-12</u>	Step #: <u>110</u>	QTY Effective: <u>± 20</u>	MRB (QSI042) Approval DAS 55 9-89 <u>19-7-13</u>																																																																	
Description Work Order Deviation		Disposition		Completed By <u>DIP 19-7-13</u>																																																																
Part moved in use during first op.		Scrap and replace		Lead hand / Supervisor Approval Verification <u>B.a 19-07-13</u>																																																																
		Batch#: <u>5092574</u>		QC / QA Coordinator Approval 40 9-89 JUL 15 2019																																																																
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